Nylon Gel Spinning:	ļ 			
RXT-2 UNIT			·	
CHANGE NUMBERS WHERE IT IS BLUE COLOR		7		
MINIMUM PUMP RPM	8			
MAXIMUM PUMP RPM	40			
PUMP SIZE(CC/REV.)	1.16			
NUMBER OF FILAMENTS	14			
PUMP SPEED(RPM)	19.7			
POLYMER DENSITY(GM/CC)	0.98			
THRU-PUT(LBS/HR)	2.95969			
THRU-PUT PER FIL(LBS/HR)	0.21141	0.21141 THRU-PUT PER FIL(GMS/MIN)	1.5982	
THRU-PUT(GMS/MIN)	22.395	22.395 THRU-PUT(GMS/MIN)	22.395	
THRU-PUT PER FIL(GMS/MIN)	1.59964			
TAKE-UP SPEED (Meter/min)	3000	FROM FT/MIN TO M/MIN	0.3048	
DPF GMS @TAKE-UP ROLL (UNDRAWN)	4.79892			
DTEX PER FIL GMS @TAKE-UP ROLL (UNDRAWN)	5.33213			
FIL DIAMETER, MICRONS (UNDRAWN)	22.1859		22.186	
FIL DIAMETER, mm (UNDRAWN)	0.02219			
TAKE-UP SPEED (FEET/min)	9842.52			
Spinnerette	diameter	length	2	AREA
INCH	0.03	60:0	3	0.0007065
CM	0.0762	0.2286	3	0.00455806
YARN DENIER @TAKE-UP ROLL (GMS)	67.1849			
FLOW RATE(CC/MIN)	22.852			
JET VELOCITY (CMMIN)	5013.54			
JET VELOCITY (meter/MIN)	50.1354	50.1354 DR @ (TAKE-UP ROLL)		59.8379407
SPIN. CAPILLARY RADIUS (FT)	0.0025			
SPIN, CAPILLARY LENGTH (FT)	0.0075			
THRU-PUT PER FIL(LBm/HR)	0.21141			
DENSITY(LBm/FT3)	61.1814			
FLOW RATE(FT3/SEC.)	9.6E-07			
VISCOSITY (POISE)	3143.9			
VISCOSITY (LBf.SEC/FT2)	6.56634			
DELTA PRESSURE(PSI)	21.4101			
Stack Draw (calc. From sprt hole dia. And fil dia.)	34.3462			
FINAL REQUIRE DENIER AFTER DRAWIN	10			
DRAWING DRAW RATIO	0.47989			
			ļ 	

Sample I.D.	Conditions	#	Ž.	æ	*	\$2	\$	#	*
				MBM 10%	MBM 10%	MBM 10%	MBM 10%	MBM 10%	MBM 10%
POLYMER TYPE	MBM	MBM		Lactam	Lactam	Lactam	Lactam	Lactam	Lactam
Feeder Setting	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96
Date	10/23/02	10/23/02	10/23/02	10/23/02	10/23/02	10/23/02	10/23/02	10/23/02	20/2/00
water on feeding zone	૪	uo	8	5	8	8	6	8	5
zone 1 Temp. (deg c)	245	270	250	250	245	240	235	230	1 %
zone 2 Temp. (deg c)	245	280	250	250	245	240	. 295	530	age of
zone 3 Temp. (deg c)	245	280	250	250	248	240	736	dec.	325
zone 4 Temp. (deg c)	245	280	250	250	245	240	735	230	2 2
zone 5 Temp. (deg c)	245	280	250	250	245	240	235	230	, z
zone 6 Temp. (deg c)	245	280	250	250	245	240	235	2 0 0	32.
zone 7 Temp. (deg c)	245	280	250	250	245	240	235	330	2 2
8 Connecting Plate Temp. (deg. C)	245	280	250	250	245	240	235	, ,	2 2
9 Block Temp. (deg.C)	245	280	250	250	245	240	32	230	2
10 Spin Pump Temp. (deg.C)	245	280	250	250	245	240	235	230	2%
11 Top Cap (deg.C)	245	280	250	250	245	240	235	230	225
12 Spin Pack Temp. (deg.C)	245	280	250	250	245	240	235	230	2
Top Heated Sleeve Length (inches)	xxx	xxx	XXX	XXX	XXX	XXX	XXXX	i k	
Top Heated Sleeve Temp. (deg. c)	χοα	хоох	XXX	XXX	XOOX	XXX	XXX	NOOK.	: {  } {! }
Bottom Heated Sleeve Length (Inches)	XXX	хоск	<b>XXX</b>	XXX	XXX	xxx	×	ž ž	; }; };
Bottom Heated Sleave Temp. (deg. c)	XXXX	XXX	3000	XXX	XXX	XXX	: 800	XXXX	
Barrel Melt Temp. (deg. c)	252	288	258	257	251	246	240	235	हि
Melt Pump Infet Pressure (psf)	2777	420	10	200	5		01	101	=
Melt Pump Outlet Pressure (pst)	nn	200	470	250	250	İ	260	380	2 5
Extruder (rpm)	200	200	200	88	200	200	200	200	200
Spinneret: no. of holes / Shape	14 R	14 R	14R	14 R	14 R	14 R	. 4 R. R.	. 47 G.	2 · 4
Spinneret: capitary diameter & depth	.024 X 0.072 .0	.024 X 0.072	.024 X 0.072						
Metering pump size (cc/rev)	1.16	1.16	1.16	1.18	1.16	1.16	1.16	1.16	1.16
Metering pump (rpm)	16.7	19.3	19.8	19.8	19.8	19.8	19.7		19.7
Thruput (lbs/hr)	2.97	2.97				2.97	2.97	2.97	2.97
Filter type	STD SCREEN	STD SCREEN S	STD SCREEN!	STD SCREEN S	STD SCREEN				
Monomer Exhaust Reading (inches water)	T80	TB0	TBO	TBD	180	TBG		<u>.</u>	
Quench air Flow rate (CF/M)	14.2	14.2	14.2	14.2	14.2	14.2	15.5	15.9	14.9
Qench air Temp. (deg. c)	19	19	19	19	19	19	19.3	19.6	19.7
Quench air Humidity %	40.8	40.8	40.8	40.8	40.8	40.8	39.8	39.5	:   66
, % Torque	20	52	23	22	20	21	20	. 54	54
Nitrogen in Hoper	3	3	က	က	3	9	9	. 3	
Need : polymer chips moisture	, Xes						f .	, , , , , , , , , , , , , , , , , , ,	
Need: Free fall samples for FAV. COOH	Yes	Yes	Yes	34	*	Yee			;

Sample I.D.	82	£10	F.	\$12	#13	#14	#15	#16	11.0
		BHS 10%		135 10%					
POLYMER TYPE	BHS	Lactam	Lactam	Lactam	Lactam	Lactam	Lactam	135	Lactam
Feeder Setting	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96
water on feeding zone	ou	8	ю	UO	5	co	ઠ	5	6
zone 1 Temp. (deg c)	252	252	247	242	237	232	227	260	260
zone 2 Temp. (deg c)	252	252	247	242	237	232	227	280	260
zone 3 Temp. (deg c)	252	252	247	242	237	232	727	280	260
zone 4 Temp. (deg c)	252	252	247	242	237	232	227	260	260
	262	252	247	Z#3-	237	222		280	280
zone 6 Temp. (deg c)	252	282	247	242	237	232	722	. 260	260
zone 7 Temp. (deg c)	252	252	247	242	237	232	227	260	260
8 Connecting Plate Temp. (deg. C)	252	252	247	242	237	232	727	260	560
9 Block Temp. (deg.C)	252	252	247	242	237	232	227	260	780
10 Spin Pump Temp. (deg.C)	252	252	247	242	237	232	227	260	560
11 Top Cap (deg.C)	252	252	247	242	752	232	227	260	260
12 Spin Pack Temp. (deg.C)	252	252	247	242	237	232	227	260	260
Top Heated Sleeve Length (Inches)	XXX	XXX	XXX	χοοχ	XXX	XXX	XXX	XXX	χα
Top Heated Sleeve Temp. (deg. c)	хоох	XXX	XXX	χοαχ	χαχ	χοα	XXX	XXX	χοα
Bottom Heated Sleeve Length (Inches)	хох	XXX	XXX	XXXX	XXX		XXX	800	χ
Bottom Heated Sleeve Temp. (deg. c)	хоох	XXX	хоох	XXX	XXX		XXX	×	. 8
Barrel Melt Temp. (deg. c)	259	260	254	249	245	i i	238	270	. 569 
Mait Pump Inlet Pressure (psl)	40	06	250	280	8	S.	20	1200	8
Melt Pump Outlet Pressure (pst)	970	520	920	610	740	790	. 64	1600	. 640 : 640
Extruder (rpm)	200	200	200	200	200	200	200 200	200	500
Spinneret: no. of holes / Shape	14R	14 R	14 R	14 R	14 R	14R	14R	14 R	4. R.R.
Spinneret: capilary diameter & depth	.024 X 0.072								
Metering pump size (cc/rev)	1.16	1.16	1.16	1.16	1.18	1.18	1.16	1.16	1.16
Metering pump (rpm)	19.7	19.7	19.7	. 19.7	19.7		19.7	19.7	19.7
Thruput (Ibs/hr)	2.97	2.97	26.2	2.97		ŀ	2.97	2.97	2.97
Filter type	STD SCREEN	ய	STD SCREEN	STD SCREEN	STU SCRFEN				
Monomer Exhaust Reading (inches water)	TBC	T80	180	TBD	T8D		3.	:	
Quench air Flow rate (CFRI)	14.6	14.5	14.6	14.9	15	14.6	14.9	14.5	15.1
Qench air Yemp. (deg. c)	19.5	18.9	19.2	19.2	18.7	19	19.4	18.5	19.2
Quench air Humidity %	38.7	39.3	39.7	41.8	39.7	40.3	39.4	38.6	41.1
% Torque	42	27	82	30	82	န္တ	53	<b>.</b>	37
Ntrogen in Hoper	က	3	အ	3	က	n	e	n	ю
Need : polymer chips moisture									
Need: Free fall samples for FAV, COOH									:

135 10% actam Lactam Lactam 2.98 02 10/24/02 00 01 240 240 240 240 240 240 240 240 240 240	135 10% 135 10% 135 10% 135 10% 135 10% 2.96 2.96 2.96 00 00 235 230 230 235 230 235 230 235 235 235 235 230 235 235 235 235 235 235 235 235 235 235	135 10% Lactam 2.96 10.24/02 0n 225 225 225 225 225 225 225 225 225 22	2.96 10/24/02 0n 300/289 300 300 300 300 300 300 300 300 300 30	195 10% Lactam 2.96 10024/02 0n 2900773 290 290 290 290 290 290 290 290 290 290
135 10% Lactam         Lactam         136 10% Lactam		2.96 10.24/02 10.24/02 2.95 2.25 2.25 2.25 2.25 2.25 2.25 2.2	195 2.96 2.96 300,269 300 300 300 300 300 300 300 300 300 30	
2.96         2.96         2.96         2.96         2.96         2.96         2.96         2.96         2.96         2.96         2.96         2.90 <t< td=""><td></td><td>2.96 10.24/02 an 225 225 225 225 225 225 225 225 225 22</td><td>2.96 10/24/02 0n 300/289 300 300 300 300 300 300 300 300 300 30</td><td></td></t<>		2.96 10.24/02 an 225 225 225 225 225 225 225 225 225 22	2.96 10/24/02 0n 300/289 300 300 300 300 300 300 300 300 300 30	
on         on         on         on           con         on         on         on           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           254         250         245         248		1024/02 on 225 225 226 225 225 225 225 225	10/24/02 0 0 300/289 300 300 300 300 300 300 300 30	
on         on         on         on           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           256         250         245         248           260         245         630		225 225 226 228 228 228 226 226 226 226 226 226	300/269 300/269 300 300 300 300 300 300 300 300 300 30	
255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           264         250         245         248           264         250         245         248		225 226 228 228 228 228 228 228 228 228 228	300/289 300 300 300 300 300 300 300 300 300 30	
255         250         245         240           256         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         248           260         264         240         248           260         245         248         248           260         260         260         260		225 228 228 228 228 228 228 228 228 228	300 300 300 300 300 300 300 300 300 300	
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255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           200         200         245         240           200         200         200         200           200         200         200         248           200         470         450         630           1080         1140         1280         1280           200         200         200         200         200           14R         14R         14R         14R           14R         14R         14R         14R           197         197         197         197           297         297         297           210         780         780           210         180         180           197         197         197           180         780         287           297         287         2		225 226 226 226 225 225 225 225 225	300 300 300/300 300/300	
255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           255         250         245         240           200         200         200         200           200         470         450         630           470         450         480         630           1080         1140         1280         1280           200         200         200         200         200           14R         14R         14R         14R           14R         14R         14R         14R           197         197         197         197           297         297         297         297           210         78D         78D         78D           180         78D         780         780           207         207         207         207         207           208         1.16         1.16         1.16         1.16           197         197         19.7         2.97         2.97		226 226 225 225 225 225	300 300/300 300/300 xxxx	
255         245         246         246         240           255         250         245         240           255         250         245         240           2000         2000         200         200           284         259         253         248           630         470         450         630           1080         1140         1280         1280           200         200         200         200           201         200         200         200           14R         14R         14R         14R           14R         14R         14R         14R           197         197         197         197           297         297         297         297           297         780         780         780           197         197         197         197           197         180         780         780           297         297         780           180         780         780         780           180         180         180         180           180         780         780         <		22 22 22 XXX	300/300 300/300 xxxx	
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XXXX         XXXX         XXXX         XXXX         XXXX         XXXX         XXXX         XXXXX         XXXXXX         XXXXXX         XXXXXXX         XXXXXX         XXXXXX         XXXXXX <th< td=""><td></td><td></td><td></td><td></td></th<>				
XXXX         XXXXX         XXXXXX         XXXXXX         XXXXXX         XXXXXX         XXXXXX         XXXXXX         XXXXXXX         XXXXXXX         XXXXXXX         XXXXXXX         XXXXXXXX         XXXXXXXX         XXXXXXXXXXX         XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX		XXX	XXXX	
284         259         263         248           630         470         450         630           1080         1140         1280         1280           200         200         200         200           14R         14R         14R         14R           14R         14R         14R         14R           15R         1.16         1.16         1.16           197         19.7         19.7         19.7           197         19.7         19.7         19.7           287         2.97         2.97         2.97           28D         78D         78D         78D           18D         78D         78D         78D           152         14.9         14.4         14.4		ΧXX	XXX	
630         470         450         630           1080         1140         1280         1280           200         200         200         200           14R         14R         14R         14R           14R         14R         14R         14R           14R         14R         14R         14R           15R         1.16         1.16         1.16         1.16           15R         19.7         19.7         19.7         19.7           287         2.87         2.97         2.97         2.97           28D         78D         78D         78D         78D           18D         78D         78D         78D         78D           152         14.9         14.5         14.4         14.4		232	312	
1080         1140         1280         1280           200         200         200         200         200           14R         14R         14R         14R         14R           1024 X 0.072         .024 X 0.072         .024 X 0.072         .024 X 0.072         .024 X 0.072           1.16         1.16         1.16         1.16         1.16         1.16           1.97         19.7         19.7         19.7         19.7           2.97         2.97         2.97         2.97           STD SCREEN         STD SCREEN         STD SCREEN         TBD           1BD         1BD         1BD         1BD           15.2         14.9         14.5         14.4		180	1480	
200         200 <td></td> <td>4700</td> <td>1290</td> <td></td>		4700	1290	
14 R         14 R         14 R         14 R           .024 X 0.072         .024 X 0.072         .024 X 0.072         .024 X 0.072           1.16         1.16         1.16         1.16           1.97         19.7         19.7         19.7           2.97         2.97         2.97         2.97           STD SCREEN         STD SCREEN         STD SCREEN         TBD           TBD         TBD         TBD         TBD           15.2         14.9         14.5         14.4		280	200	
024 X 0.072         .024 X 0.072 </td <td>!</td> <td>. <u>7</u></td> <td>14 R</td> <td></td>	!	. <u>7</u>	14 R	
1.16         1.16         1.18         1.16           19.7         19.7         19.7         19.7           2.97         2.97         2.97         2.97           STD SCREEN         STD SCREEN         STD SCREEN         TBD           TBD         TBD         TBD         TBD           15.2         14.9         14.5         14.4	272	.024 X 0.072	024 X 0.072	
19.7         19.7         19.7         19.7           2.97         2.97         2.97         2.97           STD SCREEN         STD SCREEN         STD SCREEN         TBD           TBD         TBD         TBD         TBD           15.2         14.9         14.5         14.4	l	1.18	1.16	
2.97         2.97 <th< td=""><td></td><td>19.7</td><td>19.7</td><td></td></th<>		19.7	19.7	
STD SCREEN         STD SCREEN         STD SCREEN         STD SCREEN           TBD         TBD         TBD         TBD           15.2         14.9         14.5         14.4	2.97 2.97	2.97	2.97	
15.2 14.9 14.5 14.4	EEN	STD SCREEN ST	TD SCREEN S	
15.2 14.9 14.5 14.4	TBD 750	-		
	14.9 14	14.2	14.6	14.8
18.7 19	18.9 19.1	18.7	18.9	19.5
40.7 39.7	_	39.1	8.96.8	33.1
39 38 40	39 40	42	52	38
3 3 3		m	e e	m
Need: polymer chips moisture				. :
Need : Free fall samples for FAV, COOH				

Sample I.D.	177	074	674	3
		195 10%		195 10%
POLYMER TYPE	195 10% Lactem	Lactam	195 10% Lactam	Lactam
Feeder Setting	2.96	2.96	2.96	2.96
Date	10/24/02	10/24/02	10/24/02	10/24/02
water on feeding zone	OU	uo	CO	é
zone 1 Temp. (deg c)	285/270	280/288	275/263	270/258
zone 2 Temp. (deg c)	285	280	275	270
zone 3 Temp. (deg c)	587	. 280	275	270
zone 4 Temp. (deg c)	285	280	275	270
zone 5 Temp. (deg c)	285	280	275	270
zone 6 Temp. (deg c)	285	280	275	270
холе 7 Тетр. (deg c)	285	280	275	270
8 Connecting Plate Temp. (deg. C)	285	280	275	270
9 Block Temp. (deg.C)	285	280	275	270
10 Spin Pump Temp. (deg.C)	285	280	275	270
11 Top Cap (deg.C)	285	280	275	270
12 Spin Pack Temp. (deg.C)	285	280	275	270
Top Heated Sleeve Length (Inches)	XXX	XXX	XXX	XXXX
Top Heated Steeve Temp. (dag. c)	χχ	xxx	χα	ΧΧ
Bottom Heated Sleeve Length (Inches)	хоох	XXX	XXX	XXX
Bottom Heated Sleeve Temp. (deg. c)	χοοα	χοοα	χοα	XXX
Barrel Melt Temp. (deg. c)	298	289	284	279
Melt Pump intet Pressure (psl)	1250	50	860	1060
Melt Pump Outlet Pressure (psi)	098	890	970	1100
Extruder (rpm)	200	200	200	500
Spinneret: no. of holes / Shape	14 R	14 R	14R	14 R
Spinneret: capitary diameter & depth	.024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072
Metering pump size (cc/rev)	1.18	1.18	1.16	1.18
Metering pump (rpm)	19.7	19.7	19.7	19.7
Thruput (lbs/hr)	2.97	2.97	2.97	2.97
Filter type	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN
Monomer Exhaust Reading (inches water)	uado	uedo	oben	uado
Quench air Flow rate (CF/M)	14.7	14.7	14.2	13.9
Qench air Temp. (dog. c)	19.2	19.7	20	18.7
Quench air Humidity %	46.1	41.5	43.1	39.4
% Torque	41	28	37	41
Nitrogen in Hoper	3	9	က	6
Need: polymer chips moisture				